

# Work Order ID 70932

Monday, June 20, 2011 8:23:23 AM

Page 1

Item ID: D206-642-311BL

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube LH

Start Date: 6/20/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-20

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

8/10/09

OK Per BG 11/09/29

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/26 (12)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/09

371937

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70932**

Monday, June 20, 2011 8:23:23 AM

Page 2

Item ID: D206-642-311BL

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube LH

Start Date: 6/20/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00

Customer:


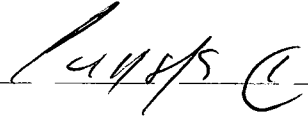

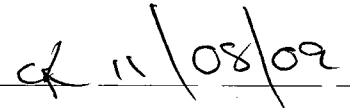

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPP D206-642-311 Location: _____ PPP Rev: <u>F</u>	0.00							
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							   11-08-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 20, 2011 8:23:30 AM

Page 1

Work Order ID: 70932

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC  
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec  
IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M  
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341

Manufactured

No

110

Each

3.0000

1

Replacement Skidtube

## Location

## Loc Qty

## Loc Code

FG082

3

36550

1

44043

1

44044

1

D206-648-013

Manufactured

No

110

Each

8.0000

1

GHW Modification

## Location

## Loc Qty

## Loc Code

FG120

8

68347

4

69933

2

70889

2

ATTN: D3414-041 - BLUE

D2932-1

Manufactured

No

110

Each

4.0000

1

Saddle LH Out, 206

## Location

## Loc Qty

## Loc Code

ST428

4

69032

4

BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 70932

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2933-1

Manufactured No

110

Each

4.0000



Saddle LH In, 206



B71062

Location

Loc Qty

Loc Code

ST421

2

67260

2

ST428

2

69030

2

BLUE

D2938-1

Manufactured No

110

Each

3.0000



Saddle LH Out, 206



B71058

Location

Loc Qty

Loc Code

ST421

3

67261

2

69033

1

ST428A

6

BLUE

D2939-1

Manufactured No

110

Each

5.0000



Saddle LH In, 206



B71056

Location

Loc Qty

Loc Code

ST421

1

67262

1

ST428A

4

69028

4

BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Page 3

Work Order ID: 70932

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-41A

Purchased

No

110

Each

251.0000

.8 8



Bolt



M112110 S

## Location

## Loc Qty

## Loc Code

ST354

251

112431

1

116191

200

117794

50

D2652

Manufactured

No

110

Each

328.0000

16



Bushing



16 13y 2x  
B70969 B71573 S

## Location

## Loc Qty

## Loc Code

FG

44

31985

44

ST019

284

68102

200

68941

84

MS21042L3

Purchased

No

110

Each

2,107.000

8



Nut



1 8 S

## Location

## Loc Qty

## Loc Code

ST300

2107

116391

9

116549

398

117441

800

117601

400

117885

500

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8



Washer



8  
M117505 11/7/27 S

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Work Order ID: 70932

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-10A Purchased No 110 Each 308.0000



Bolt



4

Location Loc Qty Loc Code

ST337 308

117313 83

117795 125

117872 100

AN5-11A Purchased No 110 Each 62.0000



Bolt



4

Location Loc Qty Loc Code

ST337 62

117313 62

AN960JD516 NAS1149D0563J Purchased No 110 Each 0.0000



Washer



8

1118206

AN4-6A Purchased No 110 Each 1,200.0000



Bolt



12

Location Loc Qty Loc Code

ST356 1000

116400 400

116924 400

117872 200

ST358 200

117514 200

AN960JD416 NAS1149D0463J Purchased No 110 Each 0.0000



Washer



25

1118179

11/12/2011

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Work Order ID: 70932

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,974.000

12

12



Nut

Location

Loc Qty

Loc Code

ST300

4974

117441

2680

117601

794

117885

1500

D3407-043

Manufactured

No

110

Each

14.0000



Tow Ring

Location

Loc Qty

Loc Code

ST464

14

68339

2

69540

12

BLUE

D3456-1

Manufactured

No

110

Each

48.0000



Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

41

66848

3

69774

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

Monday, June 20, 2011 8:23:32 AM

Page 6

Work Order ID: 70932

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

110

Each

18.0000

2

2



Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

8

67779

8

MS21043-4

Purchased No

110

Each

1,111.000

1

1



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

71

117423

71

ST301

1000

117601

500

117793

500

AN4C5A

Purchased No

110

Each

517.0000

1

1



BOLT

Location

Loc Qty

Loc Code

FP-B

110

112243

110

ST345

407

112243

407

AN960C416

NAS1149C0463  
R

Purchased No

110

Each

0.0000

1

1



washer



1117735

11/7/27

Monday, June 20, 2011 8:23:32 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 20, 2011 8:23:32 AM

Page 7

Work Order ID: 70932

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110 Each

21.0000



Ring



Location

Loc Qty

Loc Code

ST420

15

62961

8

66387

7

ST473

6

66945

6

BLUE

D2712

Manufactured No

110 Each

301.0000



Set Screw



Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

251

66955

251

D2934

Manufactured No

110 Each

44.0000



Saddle Spacer



Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

38

67585

10

69745

28

Monday, June 20, 2011 8:23:32 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 20, 2011 8:23:33 AM

Page 8

Work Order ID: 70932



Parent Item: D206-642-311BL



Parent Item Name: Skidtube LH

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

34.0000

2

2



Saddle Spacer



B70770 1/2 hof

Location

Loc Qty

Loc Code

ST027

34

66564

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 4.5 206 L/L-1/L-3/L-4/407 LOW &amp; HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG <sup>(1)</sup>
2B			14			D2651-3	* O-RING <sup>(1)</sup>
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			MS27039-1-08	* SCREW <sup>(1)</sup>
5			2			AN960JD10L	* WASHER <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT <sup>(2)</sup>
14	4	4				AN5-11A (OR AN5-12A)	* BOLT <sup>(2)</sup>
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: <sup>(1)</sup> DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE<sup>(2)</sup> CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N

Date: 09.09.09